

D:\9:
USC
Tuesday, 19/08/2008 4:06:06 PM
Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SQUARE TUBE	
Job Number	: 41477				
Estimate Number	: 13469				
P.O. Number	:		Part Number	: PB6743001113	
This Issue	: 19/08/2008	S.O. No. :	Drawing Number	: B6743001 PAGE33	
Prsht Rev.	: NC		Project Number	: N/A	
First Issue	: / /	Type : MACHINED PARTS	Drawing Revision	: B1	
Previous Run	: 40599		Material	:	
Written By	:		Due Date	: 18/09/2008	
Checked & Approved By	: <u>JUL 08.8.20</u>		Qty:	12	Um: Each
Comment	: Est Rev:A 08-07-17 new issue DD verified by:EC				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6TS1000W 125 120	6061T6 SQ TUBE 1.00 x 1.00 x .125w
	Comment: Qty.: 1.9425 f(s)/Unit Total : 23.3100 f(s) 6061T6 SQ TUBE 1.00 x 1.00 x .125w batch: <u>710 9057</u>	<u>SAD 08/08/02</u>
2.0	BAND SAW	BAND SAW
	Comment: Cut blank as per dwg PB67-43001	<u>SAD 08/09/02</u>
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
	Comment: CONVENTIONAL MILLING MACHINE Mill as per Dwg B67-43001 DO NOT MILL 1.75" RAD Deburr	<u>NPA JUN 08/10/02</u>
4.0	Q62 QC5	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<u>SAD 08/10/02</u>
5.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
	Comment: HAAS CNC VERTICAL MACHINING #1 1- Mill as per Folio FA767 Rev: <u>A</u> & Dwg B67-43001 Rev: <u>B1</u> 2- Deburr per dwg B67-43001	<u>JKL 08/10/10</u>
		<u>71A issue P10-71276 metec C108/09/11 (12)</u>
		<u>71B: need + inspect C+C attached C8/10/01 (12)</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 19/08/2008 4:06:06 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SQUARE TUBE

Job Number: 41477

Part Number: PB6743001113

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC2



INSPECT PARTS AS THEY COME OFF MACHINE

n/a

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

7.0 QC6



SECOND CHECK



Comment: SECOND CHECK

8.0 PACKAGING 1



PACKAGING RESOURCE #1



18x

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 51A

Global

SP

9.0 QC21



FINAL INSPECTION/W/O RELEASE



08/10/16 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-10-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
12	B67-043001 113	Square tubing without cut-out	B41477 7127

MATERIAL: supplied by DART M6061-T6 TS1000X.120 wall M109057

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Denise Robinson

*S
08/10/02*

Vankleek Hill, October 1, 2008



DART AEROSPACE LTD	Work Order:	41477
Description: SQUARE TUBE	Part Number:	PB674B001-113
Inspection Dwg: B1743001 Rev: B1		Page 1 of 1

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FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by:	<i>Jin</i>	Audited by:	<i>S</i>	Prototype Approval:	<i>n</i>
Date:	08/10/16	Date:	08/10/16	Date:	08/10/16

Rev	Date	Change	Revised by	Approved
A		New issue	KJ/JLM	